

Date:
User:Monday, 1/8/2007 10:50:27 AM
Kim Johnston

Process Sheet

split 07/10/11

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30150
 Estimate Number : 10464
 P.O. Number : NIA
 This Issue : 1/8/2007 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NIA Type : SMALL /MED FAB
 Previous Run : 29647
 Written By : 07.01.08
 Checked & Approved By : 07.01.08
 Comment : Est:A 04.04.19 New issue KJ/JLM

Drawing Name : SUPPORT ASSEMBLY
 Part Number : D3278041
 Drawing Number : D3278 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : NIA
 Due Date : 1/20/2007

Qty: 50 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 30150A SUPPORT



Comment: Sub-Component SUPPORT

1 X D3278-1 B 29647A (x20) ml

2.0 30150B SUPPORT



Comment: Sub-Component SUPPORT

1 X D3278-2 B 29647B (x20) ml

3.0 D32783 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3278-3	Spacer	<u>29647A</u> (x20)

4.0 MS20426AD37 RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
4	MS20426AD3-7	Rivet	<u>16199</u> (80)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

(X19)

(PTO)

ml 09/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/11	5	<p>Dep 2 pieces</p> <p>1x D3278-1 support</p> <p>1x D3278-3 spacer</p> <p>2x rivets MS20426AD-6</p>		<p>Be more carefull when removing rivet</p> <p>Scrap 1x D3278-1 support</p> <p>1x D3278-3 spacer</p> <p>2x MS20426AD-3-C</p>	<p>SB</p> <p>07/01/11</p>	<p>07/01/11</p>	<p>07/01/11</p>	<p>07/01/11</p>
		When drilling out the scrap rivet. The drill was went sideways and drill in support and oversize the hole in spacer.						

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:28 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 30150

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/11 (19)

7.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

B29377

X40

(X100)

ml

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

M103154

M101938 X20

M101938 X28

(X20)

M102630 (X52)

ml

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 200.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416

Description

Washer

Batch

M101938

X80

(X200)

ml

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

2 MS21042L4

Description

Nut

Batch

M19185

X40

(X100)

ml

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

ml 07/01/11 X19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:28 AM
User: Kim Johnson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 30150

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/07/01/11 (19)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57105

1/27/01/11 (19)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/27/01/11 (19)

Job Completion



1/27/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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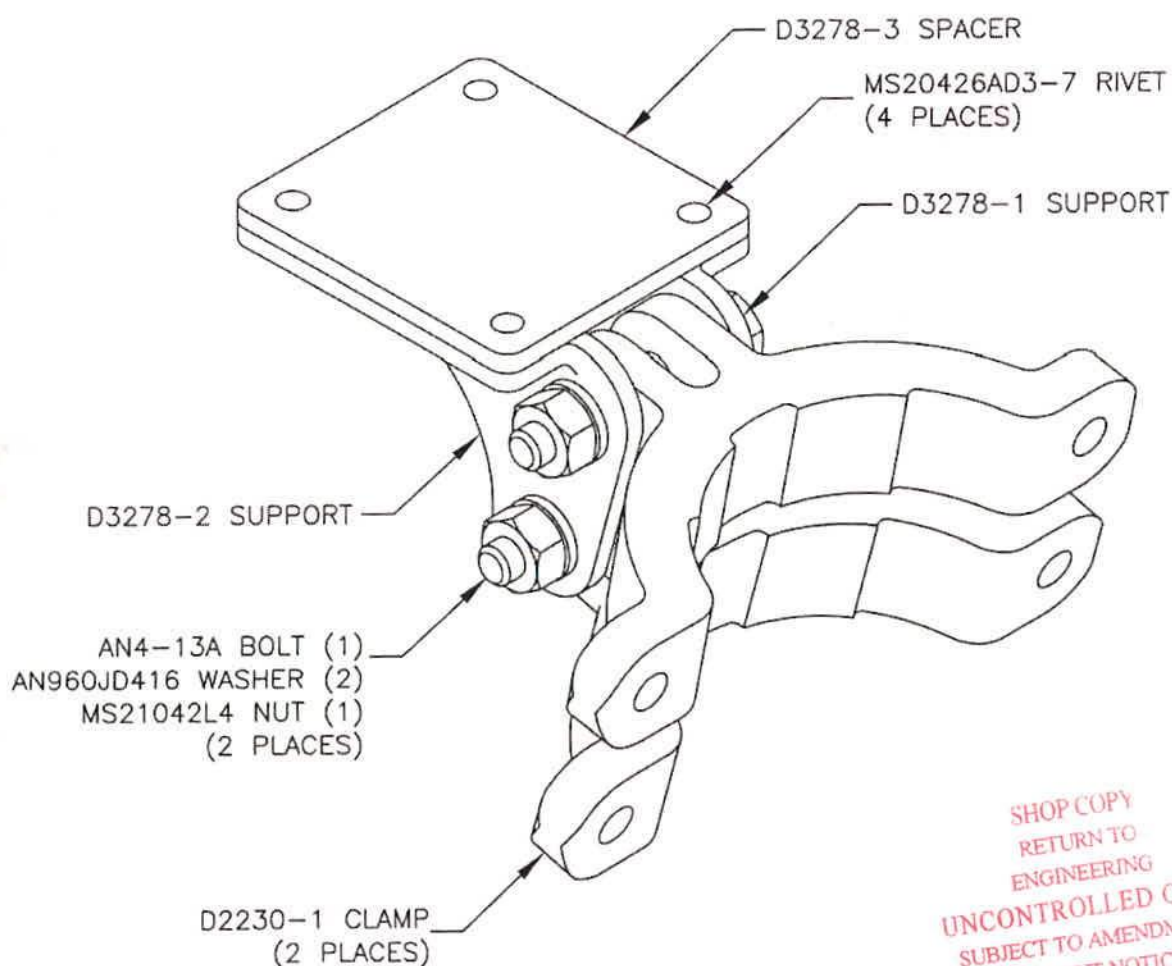
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY



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WORK ORDER
NO. 30150

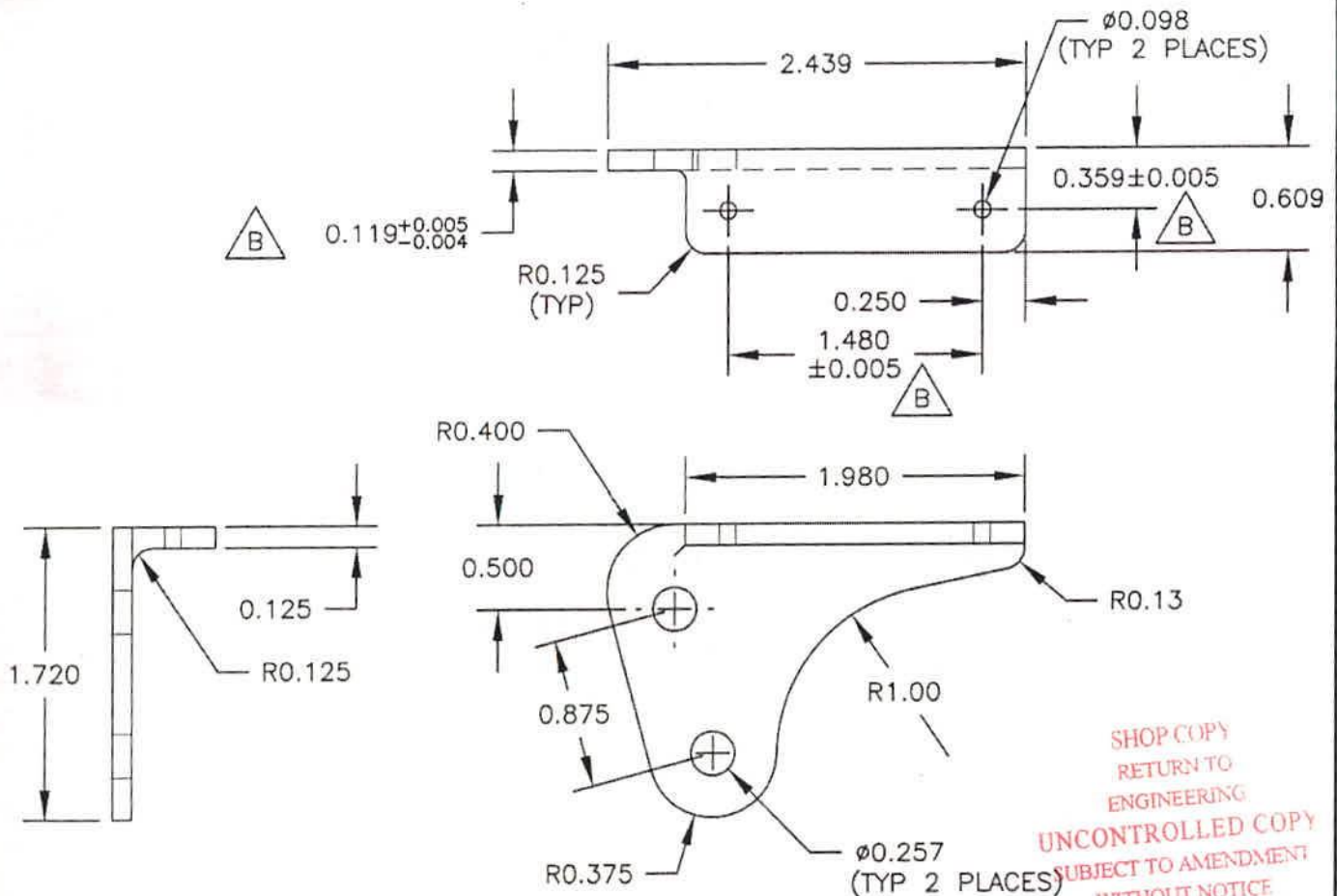
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

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05-04-04 *[Signature]*

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WORK ORDER
NO. 30150

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

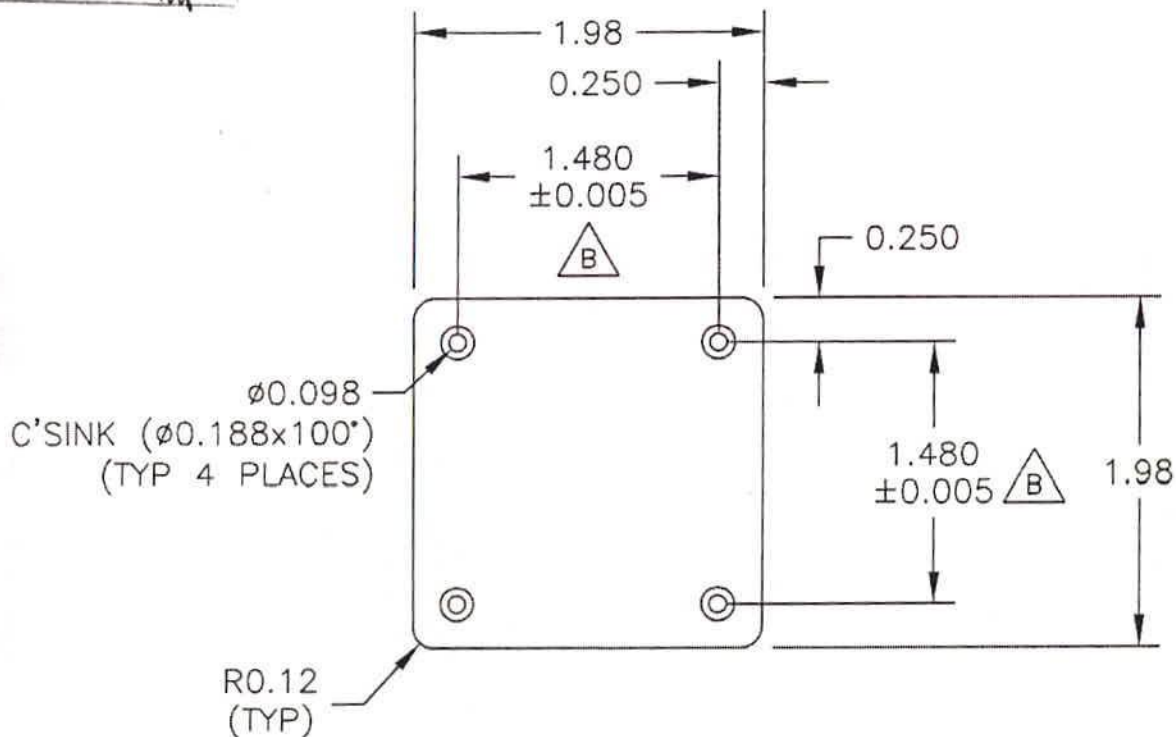
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED05.04.04 *[Signature]*

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WORK ORDER
NO. 30150

D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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